



Dart Aerospace Ltd.
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Tel (613) 632-5200

C250-1100
Job Sheet 172887



Part No: C250-1100

Job Qty: 1 ea

Part Name: C250 Cage



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/22/18

Job Tracking No:

Due Date: 2/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: C250-1100 REV.1 IPP REV:A 18.02.22 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/27/18	0.00	0.00	Start Up Large Fab-7		FL
100	Large Fab	1 pcs		2/27/18	0.00	10.00	Large Fab 8		FL
110	QC	1 pcs		2/27/18	0.00	0.00	QC9		80 18-05-11
120	QC	1 pcs		2/27/18	0.00	0.00	QC5		80 18-05-11
130	Powdercoat	1 pcs		2/28/18	0.00	0.50	Powdercoat6		80 18-05-11
140	QC	1 pcs		2/28/18	0.00	0.00	QC3		80
150	Packaging	1 pcs		2/28/18	0.00	0.00	Packaging3-2		MAY 14 2018
160	QC21-SA	1 Ea		2/28/18	0.00	0.00	QC21		

Part Op 100 - MANUFACTURE AS PER DWG, TACK WELD FOR INSPECTION BY: _____ USE WELDING JIG C/PC250.

Descriptions: ***ALL HOLES MUST ALIGN***

130 - START TIME: 9:15 OVEN TEMPERATURE: 320° FINISH TIME: 9:45

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
C250-1100-1	Bumper Bracket Weldment	1 Ea (1 ea)	90-Start up Operation	5070410
C250-1100-11	Cage Boss	4 Ea (4 ea)	90-Start up Operation	5070409
C250-1100-13	Front Plate	1 Ea (1 ea)	90-Start up Operation	5070411
C250-1100-15	Lifting Plate	2 Ea (2 ea)	90-Start up Operation	5046541
C250-1100-17	Limiting Plate	1 Ea (1 ea)	90-Start up Operation	5046461
MT-A513-T-1.000W0.120	A513 Seamless Alloy Steel Round Tubing 1"dia. x 0.120" Wall	20 ft (20 ea)	90-Start up Operation	5033394

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	C250-1100-1	1	0	0
	C250-1100-11	4	0	0
	C250-1100-13	1	0	0
	C250-1100-15	2	0	0
	C250-1100-17	1	0	0
	MT-A513-T-1.000W0.120	20	80	0

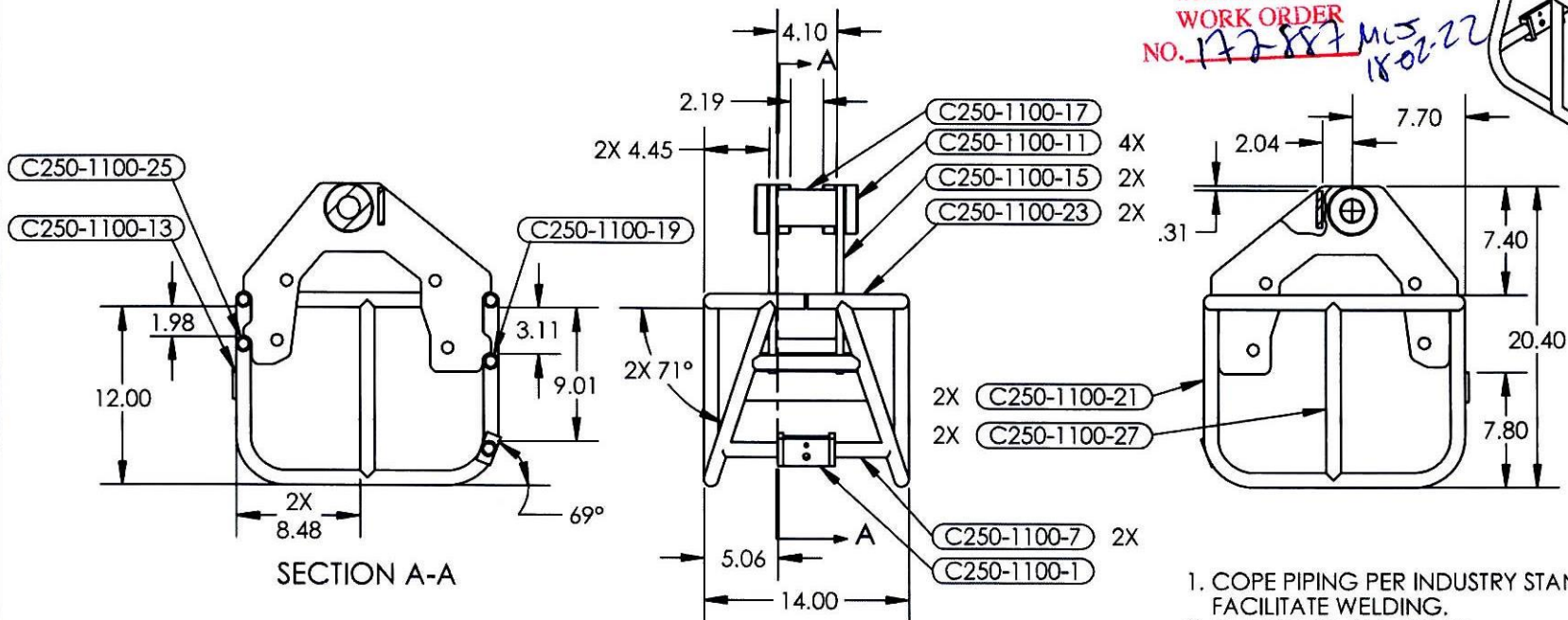
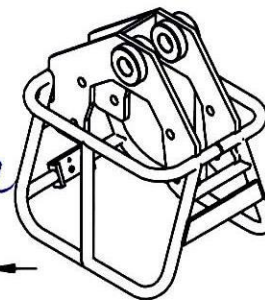
Part Specifications
Specifications could not be found.

Plex 2/22/18 1:29 PM Dart.lajeunesse.marie

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	AS DRAWN BY APICAL	6/14/2013	CFS	

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 172887 MJS
180222



1. COPE PIPING PER INDUSTRY STANDARD TO FACILITATE WELDING.
2. FILLET WELD ALL JOINTS.
3. DIMENSIONS FOR REFERENCE ONLY, ASSEMBLY MUST CONFORM TO WELD FIXTURE C/PC-250.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description
	X		C250-1100-1	1	BUMPER BRACKET WELDMENT
	1		C250-1100-3	1	FRONT PLATE-BUMPER BRACKET
	1		C250-1100-5	2	SIDE PLATE-BUMPER BRACKET
			C250-1100-7	2	BUMPER TUBE
			C250-1100-11	4	CAGE BOSS
			C250-1100-13	1	FRONT PLATE
			C250-1100-15	2	LIFTING PLATE
			C250-1100-17	1	LIMITING PLATE
			C250-1100-19	1	MID TUBE
			C250-1100-21	2	SIDE HOOP
			C250-1100-23	2	TOP RING
			C250-1100-25	1	TOP TUBE
			C250-1100-27	2	SIDE TUBE

RED BARN MACHINE	
TITLE C250 CAGE	
DWG NO. C250-1100	REV 1
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 .XX ± .03 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	DRAWN BY: APICAL APPROVED: <i>D Weil</i> HEAT TREAT FINISH: POWDER COAT RED SPEC USED ON MODEL
SCALE 1:12	DATE 6/23/2004
SHEET 1 OF 1	



Inspector:

Date: 05/11/18